



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6505G00831-3G-1
Job Sheet 168796



Part No: RBW6505G00831-3G-1

Job Qty: 1 ea

Part Name: Leg Assembly Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/23/17

Job Tracking No:

Due Date: 11/30/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6505G00831-3G Rev2 IPP Rev A 17.11.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/29/17	0.00	0.00	Start Up Large Fab-7		<i>CL</i>
100	Large Fab	1 pcs		11/30/17	0.00	1.00	Large Fab 3		<i>CL</i>
110	QC	1 pcs		11/30/17	0.00	0.00	QC9		<i>CL</i>
120	Outsource	1 pcs		11/30/17	0.00	0.00	Outsource3		<i>SP18-01-10</i>
130	Packaging	1 pcs		11/30/17	0.00	0.00	Packaging2		<i>SP18-01-10</i>
140	QC	1 pcs		11/30/17	0.00	0.00	QC6		<i>AT 18/01/22</i>
150	Packaging	1 pcs		11/30/17	0.00	0.00	Packaging3-2 <i>GA</i>		
160	QC21-SA	1 Ea		11/30/17	0.00	0.00	QC21		

Part Op 100 - Weld as per DWG.

Descriptions: 120 - Issue P/O to Groupe Altech: P/O *38684* -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow - Certificate of Conformity is required

DAS
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DART
AEROSPACE
S030916



Leg Assembly Weldment

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Std Qty
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)

marie.marie

PART NO:

RBW6505G00831-3G-1

Revision:

Operation:

Outsource

Change No:

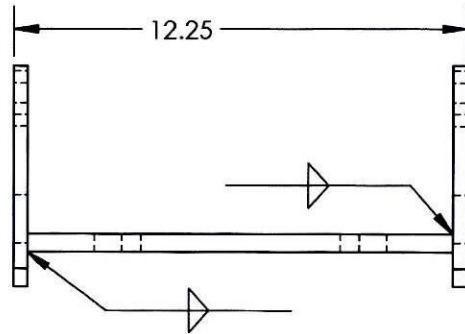
Mfg Date: 01/10/18

Job No: 168796

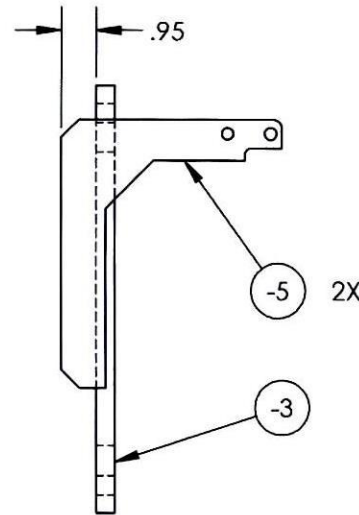
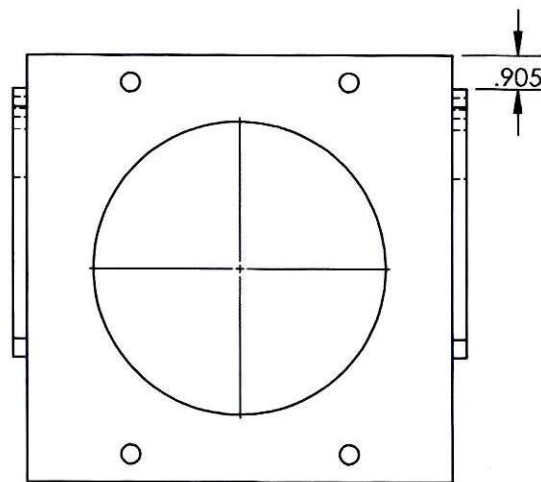
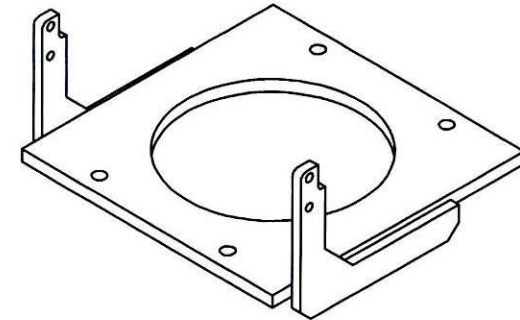
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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL

TEO ATTACHED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168796 M5
17-11-23



(-1)
LEG WELDMENT

RED BARN MACHINE	
TITLE TROLLEY ADAPTER, TGB SUPPORT	
DWG NO. RBW6505G00831-3G-1	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	DRAWN BY: CLOUGH APPROVED D Weil HEAT TREAT FINISH CAD PLATE YELLOW SPEC QQ-P-416F, TYPE II, CLASS II USED ON MODEL AW139
SCALE 1:5	DATE 2/6/2012
SHEET 3 OF 16	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038684**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO038684
PO Date: 12/19/17
Due Date: 1/3/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

E-MAILED

DEC 20 2017

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	168797	RBW6505G00831-3G-7	Swivel Plate Weldment -Issue P/O to Groupe Altech: P/O _____ -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow - Certificate of Conformity is required	Firmed	1/3/18	1 pcs	0 pcs	1 pcs	\$58.3333/pcs	\$58.33
2	168796	RBW6505G00831-3G-1	Leg Assembly Weldment -Issue P/O to Groupe Altech: P/O _____ -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow - Certificate of Conformity is required	Firmed	1/3/18	1 pcs	0 pcs	1 pcs	\$58.3333/pcs	\$58.33
3	169248	RBW6505G00831-3G-21	Swivel Plate -Issue P/O to Groupe Altech: P/O _____ -Cadmium plating, QQ-416F TYPE II, CLASS II -Color; Yellow - Certificate of Conformity is required	Firmed	1/3/18	1 pcs	0 pcs	1 pcs	\$58.3333/pcs	\$58.33
4	169589	RB6796941-201-3	Plug -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	1/3/18	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Certificat de Conformité / Certificate of Compliance



Bon de Livraison / Packing Slip

005425- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
08-Jan-2018		Ross Montieth		038684				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6505G00831-3G-7 Rev.	SWIVEL PLATE WELDMENT 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-416, TYPE II, CLASS II: CADMIUM YELLOW ***	CADMIUM	1	1	0	0	0
2	RBW6505G00831-3G-1 Rev.	LEG ASSEMBLY WELDMENT 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-416, TYPE II, CLASS II: CADMIUM YELLOW ***	CH CADMIUM	1	1	0	0	0
3	RBW6505G00831-3G-21 Rev.	SWIVEL PLATE 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-416, TYPE II, CLASS II: CADMIUM YELLOW ***	CADMIUM	1	1	0	0	0
4	RB6796941-201-3 Rev.	PLUG BLACK OXIDE MIL-C-13924C CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
5	647.8510 Rev.	647.8510 PASSIVATE ,MIL-S-5002 TYPE 6	PASSIVATION CH	80	80	0	0	0

8/18-01-10

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements
 Our financial and legal responsibility will not be higher than the amount of invoice.